AMENDMENTS TO THE CLAIMS:

Please amend the claims as follows:

1. (Currently Amended) A stamping process in which a metal sheet is stamped between a bottom die and a punching die clamped by a first blank holder and a second blank holder, characterized in that the second blank holder, at an end adjacent to the punching die which is a front end of the second blank holder, has a convex form which permits progressive deformation of the metal sheet in depth and over a blank holder length~~, and is not a right angle blank holder~~.

2. (Previously Presented) A stamping process in which a metal sheet is stamped between a bottom die and a punching die clamped by a first blank holder and a second blank holder, wherein the second blank holder is geometrically adapted to a the level of an area adjacent to the punching die in order to reproduce a portion of the form created by the punching die, wherein said portion can be precisely one-half, or more than one-half, up to the entirety of the form created by the punching die.

3. (Previously Presented) The stamping process as specified in claim 1, wherein the first blank holder also has a convex form.

4. (Previously Presented) The stamping process as specified in claim 1, wherein a geometric adaptation of the second blank holder AR represents one-half the form created by the punching die.

5. (Previously Presented) The stamping process as specified in claim 1 adapted for manufacture of multiple-seat benches that have two to six or eight seats or more, requiring several consecutive seat forms or imprints separated by interval i,

wherein use is made of a tool the second blank holder of which reproduces in its part B at least one portion that can be precisely one-half (A) of the seat form created by the punching die, or optionally more than one-half, up to the totality, of the form created by the punching die.

6. (Previously Presented) The stamping process as specified in claim 5 adapted for manufacture of multiple-seat benches that have six to eight or more seats, requiring a plurality of consecutive seat forms or imprints separated by an interval i, wherein the second blank holder and the punching die are in an area the geometry of which is adapted for reproduction of the desired form of the interval i defined as mandatorily present between two consecutive seat forms.

7. (Previously Presented) The stamping process as specified in claim 5 adapted for manufacture of multiple-seat benches that have two to six or eight or more seats, requiring a plurality of consecutive seat forms or imprints separated by an interval i.

8. (Previously Presented) The stamping process as specified in claim 5, adapted for manufacture of multiple-seat benches that have two to six or eight or more seats, requiring a plurality of consecutive seat forms or imprints separated by an interval i, wherein the profile of the first blank holder is horizontal.

9. (Previously Presented) The stamping process as specified in claim 5, wherein the first blank holder has a slightly convex surface or profile favoring transition in deformation from the metal sheet to the punching die.

10. (Previously Presented) The stamping process as specified in claim 1, wherein the metal sheet is positioned so as to produce a first stamping form or initial stamping and then the metal sheet which has undergone this first stamping or initial stamping is then displaced toward the rear and the initial stamping is brought to rest in the second blank holder, after which a second stamping is repeatedly carried out until 2, 3, 4, 5, 6, 7, or 8 imprints or more have been produced.

11. (Previously Presented) The stamping process as specified in claim 1, wherein the second blank holder reproduces in a part B one-half of the seat imprint, which is identical to a half-form of the punching die, an arrow indicating the direction of step-by-step movement of the metal sheet to permit production of consecutive imprints.

12. (Previously Presented) The stamping process as specified in claim 1, wherein the tool comprises, between the second blank holder and the punching die, a shoulder which reproduces the interval i which must be present between two consecutive seat imprints.

13. (Previously Presented) The stamping process as specified in claim 1, wherein a pressure of 150 to 300 or 350 is applied for a metal sheet of 15/10 mm or of 12/10 mm or of 10/10, 8/10, or 6/10 mm.

14. (Previously Presented) The stamping process as specified in claim 1, wherein this shoulder forming interval i is reduced to values of 1 to 3 or 5 cm for 15/10 mm metal sheets, or measuring 10/10 or 8/10 or 6/10 mm, or to a value i = 0, without marking and without folds or curls.

15. (Previously Presented) The stamping process as specified in claim 1, wherein at least one part of base part B of blank holder AR is replaced with other support means or by friction rollers.

16. (Previously Presented) The stamping process as specified in claim 1, wherein the stamping process comprises a metal sheet performing step by means of a folding machine.

17. (Previously Presented) The stamping process as specified in claim 16, wherein the metal sheet is preformed along line a, b, c, rounded part d, e, f, with all sections being straight except curved section d, or the preform is made up of sections a, h (straight), d, e, f, or the preform is made up of sections a, h (straight), d, g (straight).

18. (Previously Presented) The stamping process as specified in claim 1, wherein the metal sheet is positioned without concern for vertical alignment with the punching die and the punching die, and the metal sheet is offset by distance m relative to the vertical alignment, and wherein the press is then lowered slowly and the metal sheet is allowed to center itself on the tool.

19. (Currently Amended) A tool for application of the stamping process as specified in claim 1, characterized in that such tool comprises a bottom die and a punching die clamped by first and second blank holders, and in that the blank holder AR is widened toward the rear and has on an end adjacent to the punching die that is the front end of the rear extremity, a convex shape that is a shape which permits progressive deformation of the metal sheet in depth~~, and over a greater blank holder length in comparison to a right angle blank holder~~.

20. (Previously Presented) The tool as specified in claim 19, wherein the second blank holder is widened toward a rear and is geometrically adapted at a level of area adjacent to the punching die for reproduction of at least a portion of the form created by punching die, said portion optionally being one-half or more than one-half, and up to the entirety of the form created by the punching die.

21. (Previously Presented) The tool as specified in claim 19, wherein the first blank holder is also wider toward a front.

22. (Previously Presented) The tool as specified in claim 19, wherein geometric adaptation of the second blank holder reproduces in a part B one-half A of the shape created by the punching die.

23. (Previously Presented) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches requiring a plurality of consecutive seat forms or imprints, of two to six or eight seats or more, separated by an interval i, wherein the second blank holder reproduces at least one portion, said portion optionally being one-half the seat form produced by the punching die, or more than one-half, up to the entirety, of the form created by the punching die.

24. (Previously Presented) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches, requiring a plurality of consecutive seat forms or imprints separated by an interval i, of two to six or eight seats or more, wherein there is between the second blank holder and the punching die an area the geometry of which is adapted for reproduction of the desired shape of the interval i mandatorily present between two consecutive seat forms, i optionally equaling zero.

25. (Previously Presented) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches of two to six or eight or more consecutive seat forms or imprints separated by an interval i, wherein the first blank holder has been wider toward the front.

26. (Previously Presented) The tool as specified in claim 19 adapted for manufacture of multiple-seat benches of two to six or eight or more consecutive seat forms or imprints separated by an interval i, wherein the tool comprises between the first blank holder and the punching die a shoulder which reproduces the interval i which must be present between two consecutive seat imprints.

27. (Previously Presented) The tool as specified in claim 19, wherein, in order that the stamping pitch may be modified as desired, the tool is designed in two separate parts by a transverse cut perpendicular to the direction of advance of the metal sheet at the level of the center of the punching die, this forming the base tool at minimum pitch, which parts separated from each other by a pitch modification value, and wherein the tool comprises one or more sets of four dismountable pieces called bottom die, punching die, and blank holder shims adapted for insertion into space in an appropriate set.

28. (Previously Presented) The tool as specified in claim 27, wherein such tool is adapted for manufacture of multiple-seat benches of two to six or eight seats or more, requiring a plurality of consecutive seat forms or imprints separated by an interval i.

29. (Previously Presented) The tool as specified in claim 26, wherein such shims of bottom die, punching die, and blank holder are fastened by a mechanical means or by bolting.

30. (Previously Presented) A stamping press equipped with a tool as specified in claim 19.

31. (Previously Presented) Stamped articles and products that include successive repetitive imprints, wherein the imprints are close together, or adjacent (i = 0), and with a plurality of seats of two to six or eight seats or more, manufactured by a process as specified in claim 1.

32. (Previously Presented) Stamped articles as specified in claim 31, wherein the articles are made with metal sheets of a thickness of 15/10, 12/10, or 10/10 mm, of a stainless steel, optionally provided with a temporary, provisional, or definitive coating, or under a finishing layer, or again made of plates of plastics or composites.

33. (Previously Presented) A set of a bottom die, punching die, and blank holder shims as specified in claim 27.